

Work Order ID 86364

June-27-12 3:46:39 PM

86364

Page 1

Item ID: D4154-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Plate

Stop ***NS2***

Start Date: 27/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/28

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4154	D

100 0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

304 . 050

Dwg Rev: 8

Prog Rev: 8

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12 0 Jm 12-6-29

12 0 Jm 12-6-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plate

Start Date: 27/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: W/E

0.00

150

Packaging

Memo

0.00

Packaging

(x12) ME 12-07-03

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/7/4
ME
12-07-03

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NOTE: Date & initial all entries

Picklist Print

June-27-12 3:46:43 PM

Work Order ID: 86364

Parent Item: D4154-1

Parent Item Name: Plate

86364

D4154-1

Page 1

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA

Purchased

No

100

sf

95.8149

4.2697

53.93305

M304S18GA

**

304/316 .050 Sheet

Jun 12-6-29

Location

Loc Qty

Loc Code

MAT020

95.814947

120604

8.66421

121626

2.65

121660

84.500737

121660

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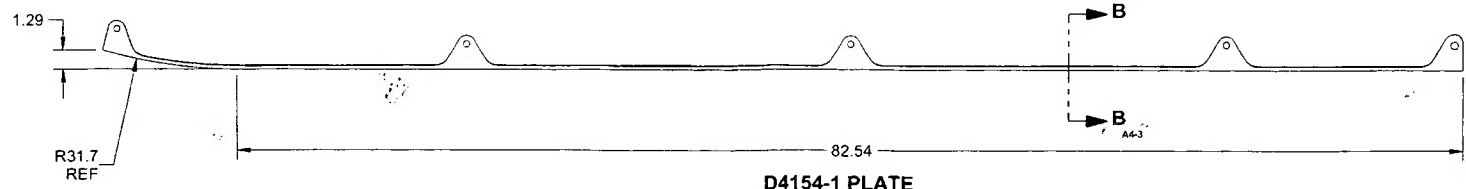
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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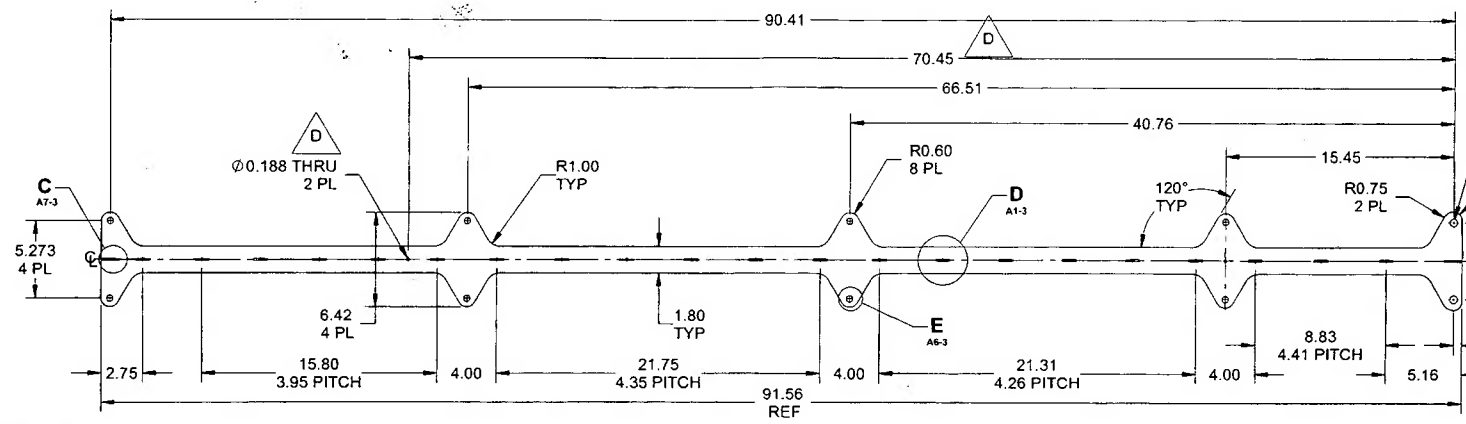
NOTE: Date & initial all entries

2.248

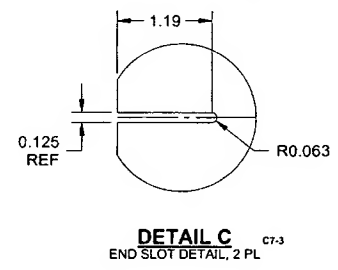
26364



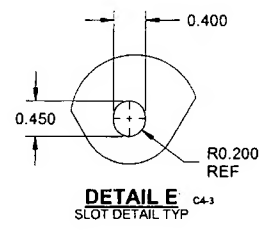
D4154-1 PLATE
(MAKE FROM D4154-1F)



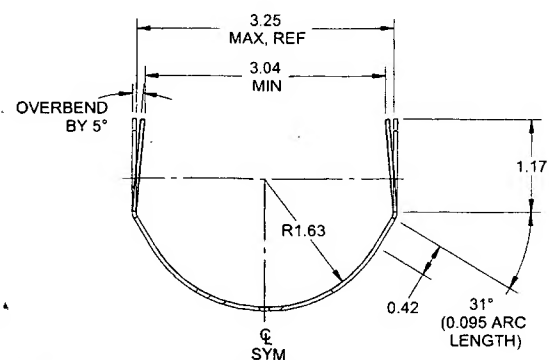
D4154-1F FLAT PATTERN



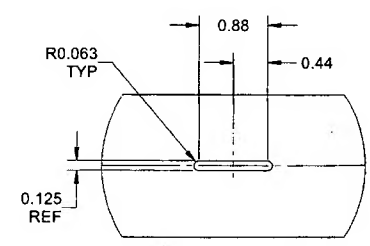
DETAIL C
END SLOT DETAIL, 2 PL



DETAIL E
SLOT DETAIL TYP



SECTION B-B
D3-3



DETAIL D
SLOT DETAIL TYP

- NOTES:**
- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
 - 2) FINISH : NONE
 - 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS : INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION : NONE
 - 7) WEIGHT : 2.95-lbs

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4154	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
DATE	12.05.03	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	X	D4154-041	WEARPLATE ASSEMBLY
2	1	D4154-1	PLATE
3	1	D4155-1	BAR
4	A/R	2059B	HARDCOAT, (SEE NOTE 9, SHT 2)
5	A/R	4714	(SEE NOTE 11, SHT 2)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 86364 MLJ
12/06/28

RELEASED
2012-05-09
MD

D4154-041 WEARPLATE ASSEMBLY

D	70 45 WAS 74 45 & Ø0.188 HOLES NOW 2 PL (ZN C4-3 & C7-3)	RF	12.05.03
C	REVISE NOTE 9 (ZN A8-2), ADD HARDCOAT (ZN B7-2); ADD DETAIL A (ZN C2-2)	RF	12.02.21
B	ITEM 4 WAS PR1422 (D3-1); REMOVED FINISH TO NOTE 2 (A8-2), REMOVED SECTION A-A (NO LONGER REQUIRED). REVISED D4154-1F	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D4154 REV. D SHEET 1 OF 3 TITLE WEARPLATE ASSEMBLY SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DRAWN	RF		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	12.05.03		

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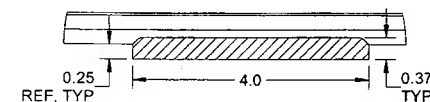
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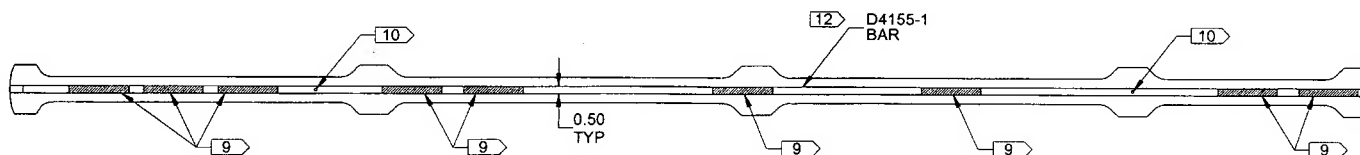
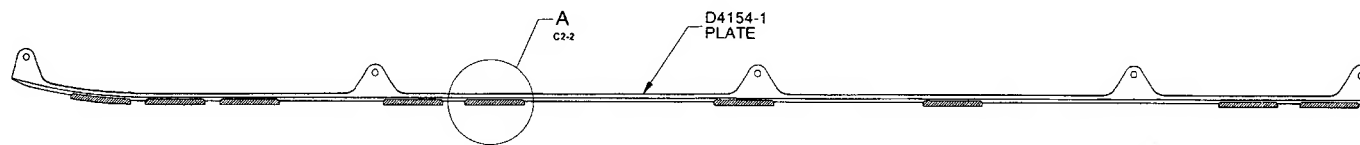
NOTE: Date & initial all entries



86364



DETAIL A
C5-2
TYP



D4154-041 WEARPLATE ASSEMBLY

RELEASED
2012-05-09

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 6.88 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.37 THICK x 0.50 WIDE, FLUSH WITH D4155-1 BAR ON LATERAL SURFACES, 9 PL
- 10) TRANSFER DRILL $\phi 0.188$ HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
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MFG. APPR.	RF	D4154	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSEMBLY	NTS
DATE	12.05.03	<small> COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. </small>	

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DART AEROSPACE LTD		Work Order: - 86364
Description: Plate		Part Number: D4154-1
Inspection Dwg: D4154	Rev: <i>[Signature]</i>	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.400 ✓	+/-0.010	0.398"	✓		✓	mm01
0.450 ✓	+/-0.010	0.454"	✓		✓	"
0.125 ✓	+/-0.010	0.124"	✓		✓	"
0.88 ✓	+/-0.030	0.878"	✓		✓	"
1.19 ✓	+/-0.030	1.178"	✓		✓	"
5.273 ✓	+/-0.010	5.269"	✓		✓	"
2.75 ✓	+/-0.030	2.62.751	✓		✓	"
15.80 ✓	+/-0.030	15.80"	✓		MT	MM01
3.95 ✓	+/-0.030	3.952"	✓		✓	mm01
4.00 ✓	+/-0.030	4.005"	✓		✓	"
6.42 ✓	+/-0.030	6.429"	✓		✓	"
21.75 ✓	+/-0.030	21.75"	✓		MT	MM01
4.35 ✓	+/-0.030	4.351"	✓		✓	mm01
1.80 ✓	+/-0.030	1.817"	✓		✓	"
21.31 ✓	+/-0.030	21.31"	✓		MT	MM01
4.26 ✓	+/-0.030	4.266"	✓		✓	mm01
8.83 ✓	+/-0.030	8.836"	✓		✓	Produced
5.16 ✓	+/-0.030	5.167"	✓		✓	mm01
0.55 ✓	+/-0.030	0.551"	✓		✓	"
91.56 ✓	+/-0.030	91.56"	✓		MT	MM01
90.41 ✓	+/-0.030	90.41"	✓		MT	"
70.45 ✓	+/-0.030	70.45"	✓		MT	"
66.51 ✓	+/-0.030	66.51"	✓		MT	"
48.59	+/-0.030					
40.76 ✓	+/-0.030	40.76"	✓		MT	MM01
15.45 ✓	+/-0.030	15.45"	✓		MT	"
5.223 ✓	+/-0.010	5.221"	✓		✓	mm01
Ø0.516 ✓	+0.008/-0.001	0.517"	✓		✓	"
Ø0.188 ✓	+0.005/-0.001	0.189"	✓		✓	"
0.050 ✓	+/-0.010	0.098"	✓		✓	"

Measured by: <i>Jm</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 12-6-29	Date: 12/6/29	Date:

Rev	Date	Change	Revised by	Approved
A	10.09.23	New Issue	KJ	
B	11.04.28	Dimensions updated per Dwg Rev B	KJ	
C	12.05.24	Dimensions updated per Dwg Rev C	KJ	<i>[Signature]</i>

Dart Aerospace Ltd

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